

Work Order ID 153467

Monday, November 21, 2016 9:23:08 AM

153467

Page 1

Item ID: D5160-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Shim
Start Date: 11/14/2016 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/21/2016 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: NOV 21 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5160	A							DAS 46 9-89	16/11/28
110		0.00							
110	FLOW WATER JET								
Waterjet	Memo	0.15							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.01							
Quality Control									
130		0.00							
130	QC8- Inspect parts - second check								
QC	Memo	0.02							
Quality Control									

DAS
38
9-89
NOV 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Monday, November 21, 2016 9:23:08 AM

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Page 2

Item ID: D5160-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 11/14/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/21/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00

140

NC BRAKE

6FF

NOV 29 2016

Small Fab

Memo

0.12

Small Fab

C'SINK HOLES AS PER DWG

150

0.00

150

QC5- Inspect part completeness to step on W/O

6

QC

Memo

0.02

Quality Control

DAS
38
9-89
NOV 7 9 2016

160

0.00

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

6 10-11-30

Powdercoat

M 134858.

Memo

0.01

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:15
320
2:00DAS
34
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 153467

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153467

Page 3

Item ID: D5160-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shim

Start Date: 11/14/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/21/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.01							
Quality Control									
180	Identify as per dwg & Stock Location: <u>51358</u>	0.00							
180									
Packaging	Memo	0.01							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.10							
Quality Control									

DAS
11
9-89

JMF 16-12-01

6

DAS
6
9-89

DEC 07 2016

DAS
21
9-89

DEC 05 2016

JMF

16-12-05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, November 21, 2016 9:23:08 AM

Page 1
1

Work Order ID: 153467

153467

Parent Item: D5160-5

D5160-5

Parent Item Name: Shim

Start Date: 11/14/2016

Required Date: 11/21/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.10.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S188		Purchased	No				sf	54.9000		0.276			
M304S188									**			DAS 46 9-89	16/11/28
304 SHEET 0.188													

Location

Loc Qty

Loc Code

MAT020

54.9

M130454

54.9

0.3

DQA: _____ Date: _____

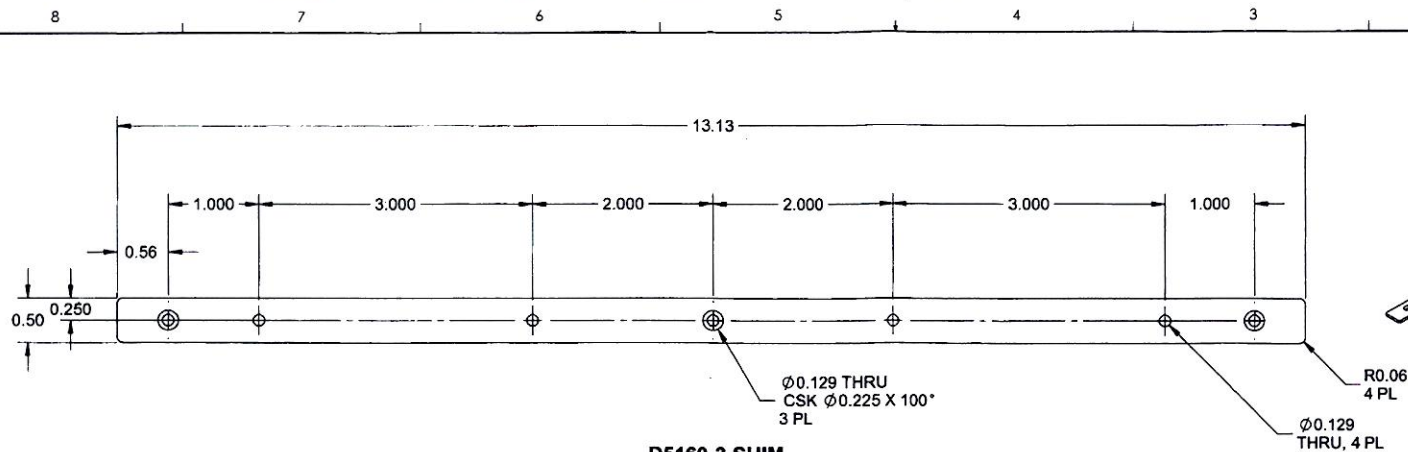


WORK ORDER NON-CONFORMANCE / UPDATE

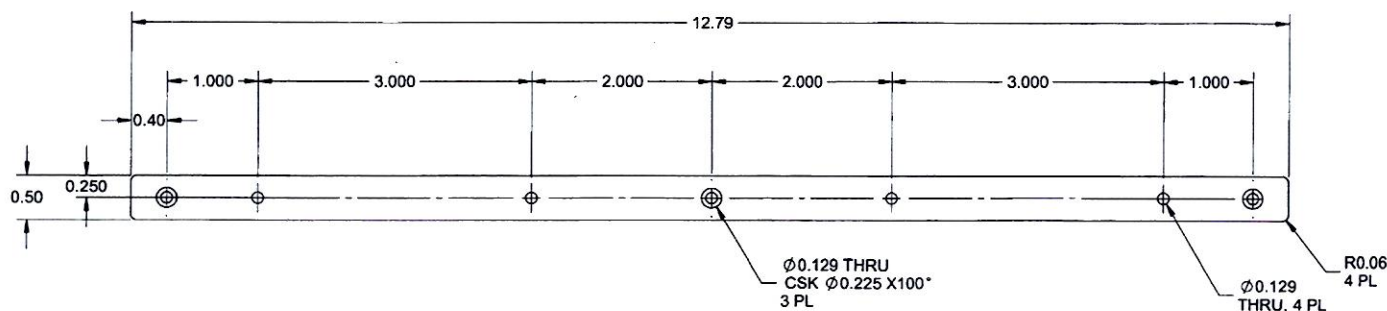
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OTHER :																																																																					



D5160-3 SHIM



D5160-5 SHIM

NOTES:

1) MATERIAL -3: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.063 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA

-5: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.188 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S7GA

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5160-X" AND B/N BXXXXX
PER DART QSI 044 6.7

7) WEIGHT -3: 0.12 lbs
-5: 0.34 lbs

RELEASED

2015 FEB 04

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5160	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SHEET METAL PARTS 350 SEAT	NTS
DATE	14.09.25	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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